

Work Order ID 85328

Tuesday, June 05, 2012 3:54:55 PM

85328

Page 1

Item ID: D3914-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Lid Assembly (350)

Start Date: 6/5/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/19/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-06-05* Tooling:Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3914

B

D4020

A

100

Weld per dwg A/R S.S. rod Batch: *4118161* 0.00***100***

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs, weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

*dy/CC 17-8-20**12*
DAS
24
9-89DAS
09
8-89*12-08-20*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hnge prior to powdercoat ***

Start Time: 1:00 320 30

Oven Temperature: 320 30

Finish Time: 1:30

140

Wing Walk as per dwg QSI005 4.4 Batch 122500 0.00

140

HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

IX ϕ M/L
12/08/201 ϕ PR 12-8-21

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

1 & (OP) 12/08/21

160

Identify as per dwg & Stock Location: 4030-041 0.00

85326

160

Packaging

Memo

0.00

Packaging

1 & (OP) 12/08/21

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 12/08/23

MF
12-08-21

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Picklist Print

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Page 1

Work Order ID: 85328

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/5/2012

Required Date: 6/19/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	55.0000	2	2			

Location

Loc Qty

Loc Code

WA
82506
83230
WA005
70766
81253
82897

12
2
10
43
2
1
40

B 85452 → (Zx)

CC 12-8-9

D3914-1
Rib

Manufactured No

100 Each 4.0000 2 2

Location

Loc Qty

Loc Code

WA
84591
WA006
81449
82131

2
2
2
1
1

B 86044 → (Zx)

CC 12-8-9

D3914-7
Rib

Manufactured No

100 Each 6.0000 2 2

Location

Loc Qty

Loc Code

WA
81209
WA006
82928

-5
1
11
5

B 87853 → (Zx)

CC 12-8-9

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Page 2

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Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/5/2012

Required Date: 6/19/2012

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No
Hinge Half, Lid

100 Each 25.0000 3 3

Location

WA
83680
84777

Loc Qty

Loc Code

25 B85776 → (3x) CC 12-8-9
7
18

D4018-5 Manufactured No
Rib

100 Each 55.0000 9 9

Location

WA
81178
WA005
80776

Loc Qty

Loc Code

54 B88675 → (9x) CC 12-8-9
54
1
1

D4020-5 Manufactured No
Mesh (350 Basket Long, Lid)

100 Each 2.0000 1 1

Location

WA
84898

Loc Qty

Loc Code

2 B85358 → (1x) CC 12-8-9
2 B87448 → (1x) CC 12-8-10

D4021-3 Manufactured No
Data Plate

100 Each 12.0000 1 1

Location

WA
80897
82507
82755

Loc Qty

Loc Code

12 B85358 → (1x) CC 12-8-9
9
1
2

D4035-041 Manufactured No
Lid Rib Assembly, Fwd (350 Basket)

100 Each 6.0000 1 1

Location

WA
63720
82985

Loc Qty

Loc Code

6 B82986 → (1x) CC 12-8-9
0
6

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Shop Packet Print

Page 2

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Picklist Print

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Page 3

Work Order ID: 85328

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/5/2012

Required Date: 6/19/2012

Start Qty: 1.00

Required Qty: 1.00

D4035-043 Manufactured No
Lid Rib Assembly, Aft (350 Basket)

100 Each 5.0000 1 1

CC 17-8-20

Location

WA
81452
82987
WA006
81202

Loc Qty

4
1
3
1
1

Loc Code

B82988 → (X)

D2728-3 Manufactured No
Dart Logo label

140 Each 0.0000 1 1

115050

1

BR 17-8-21

Tuesday, June 05, 2012 3:54:55 PM

Shop Packet Print

Page 3

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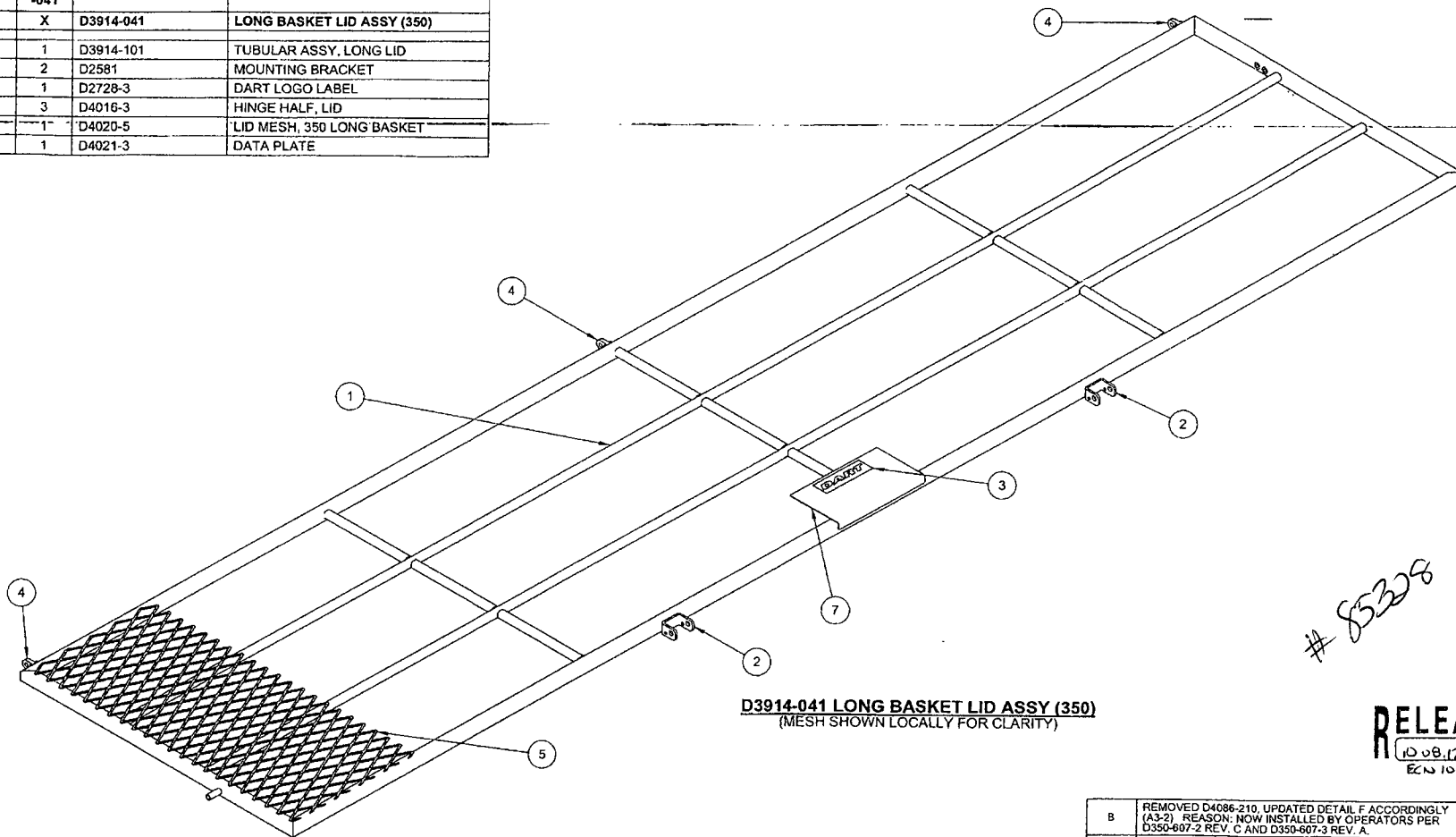
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

85328

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2) REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.		MB	10.08.05
A	NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	ALS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		DRAWING NO.	REV. B
CHECKED	SC		D3914	SHEET 1 OF 4
MFG. APPR	SC		TITLE	SCALE
DE APPR.	SC		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

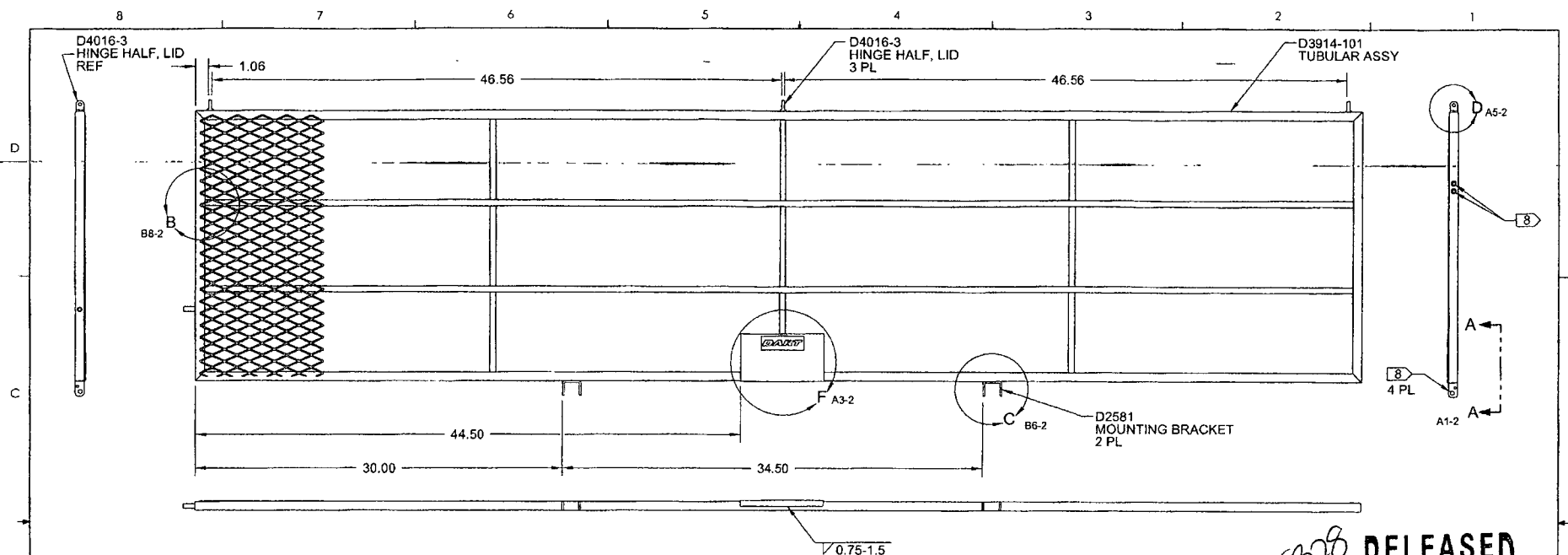
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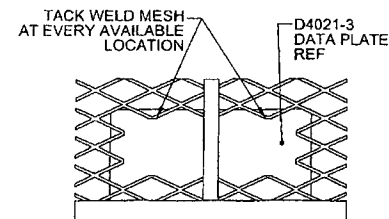
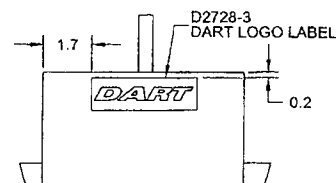
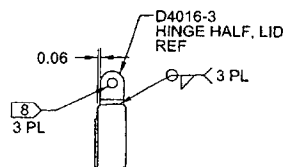
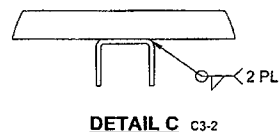
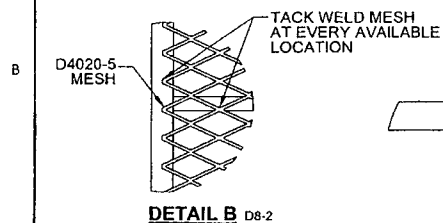
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3914	REV. B
MFG. APPR.	SC		SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

#85328 RELEASED
10-08-12 up

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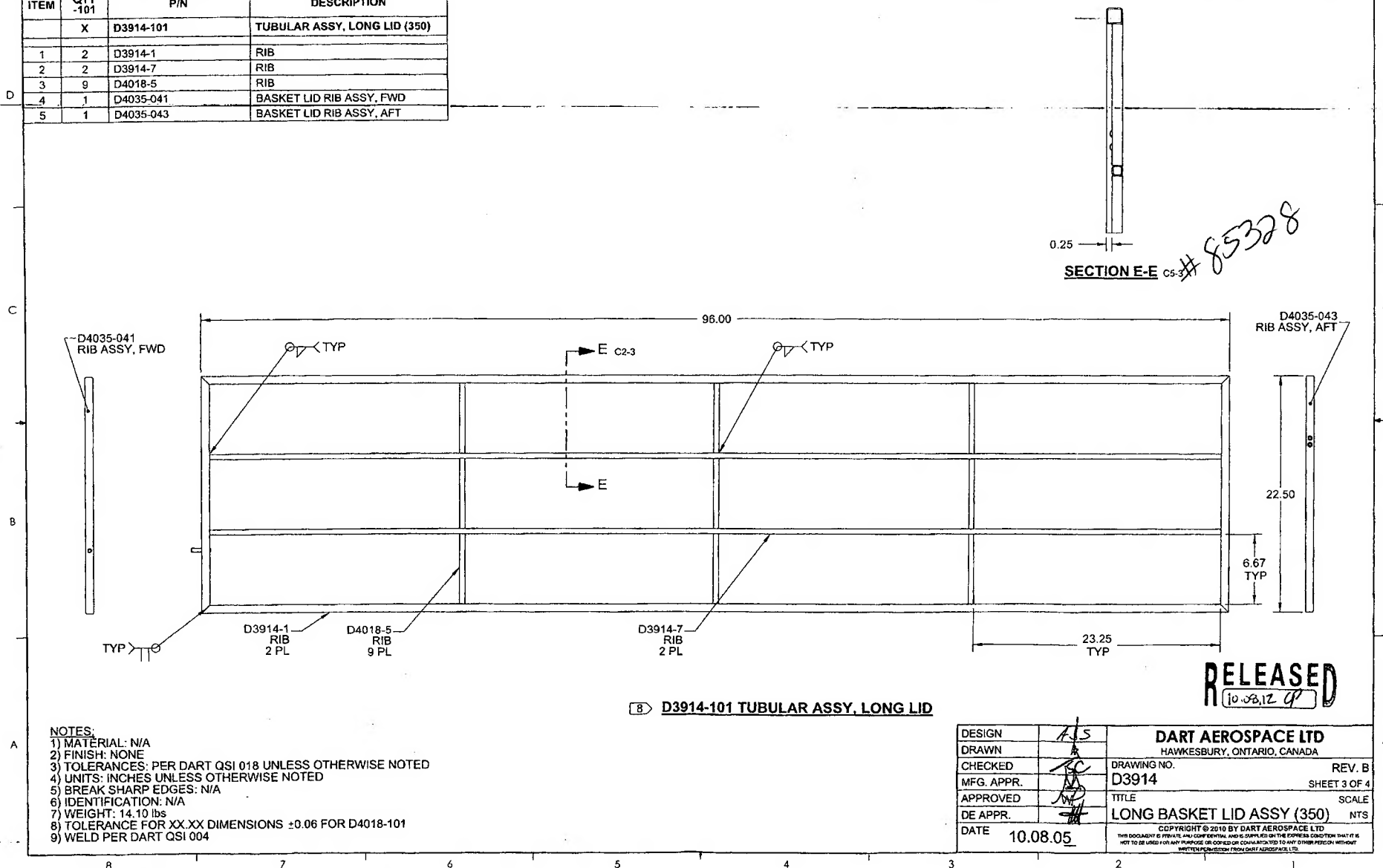
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3914	REV. B
CHECKED	SC		SHEET 3 OF 4
MFG. APPR.	WJ	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
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DE APPR.	WJ	DATE 10.08.05	

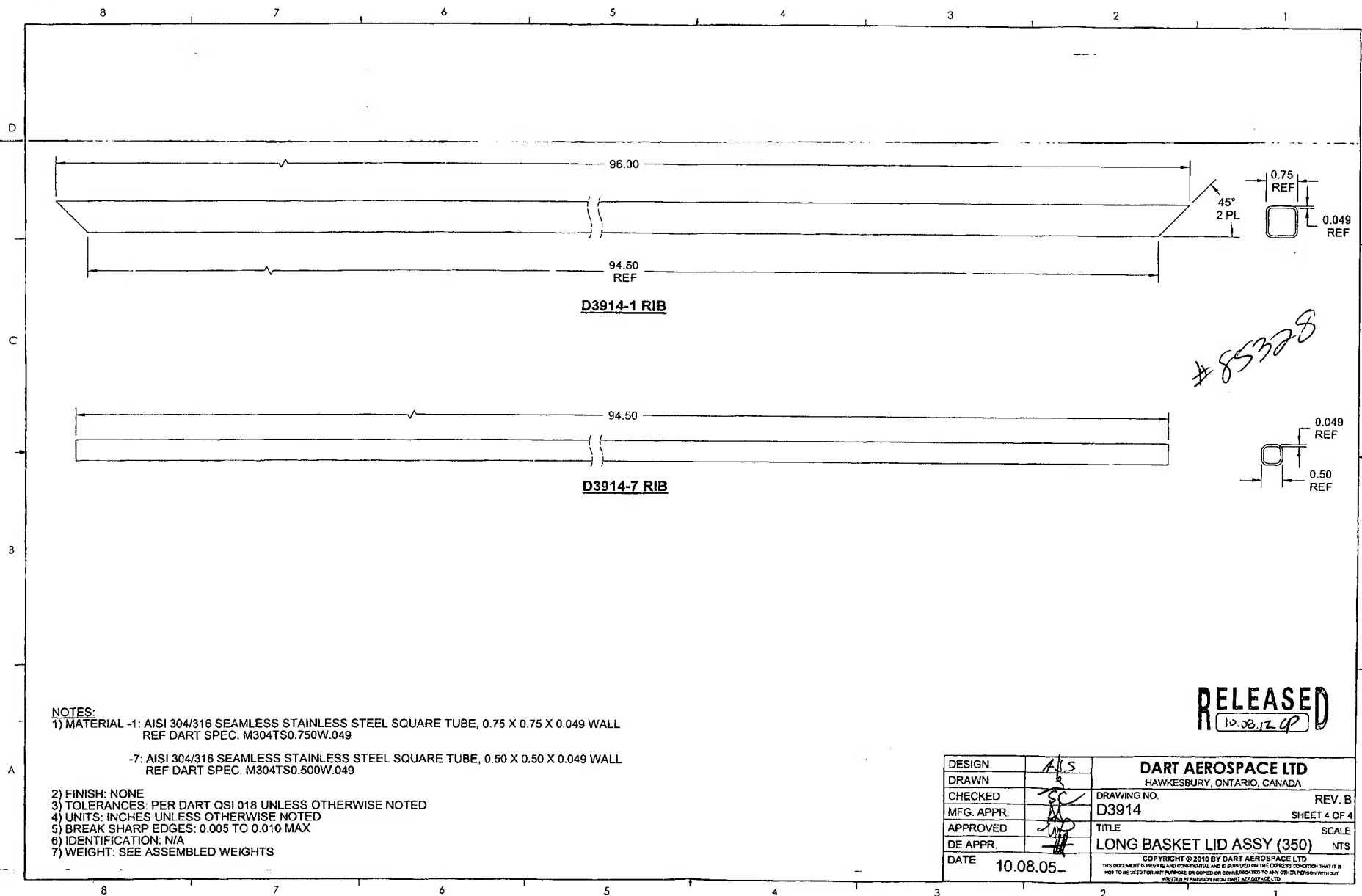
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